

Patent Claims

1. A method of manufacturing a floor panel (2), the method comprising the steps of:
 - providing a panel body (12) having a core (3, 13), a top side (3a, 13a) of said core (3, 13) being provided with a top surface layer (4), said panel body (12) further having a side surface (13b) extending transversely to the top surface layer (4);
 - forming a recess (15) extending under the top surface layer (4) from the side surface (13b) into the panel body (12) by leaving a freestanding ledge (16) including said top surface layer (4), said recess (15) having opposing first and second recess surfaces (15a, 15b); and
 - closing said recess (15) by fixing the first and second recess surfaces (15a, 15b) to one another, thereby forming a floor panel (2) having a beveled top edge (10a, 10b, 25, 26) with the top surface layer (4) extending continuously and in one piece from the top side (3a, 13a) of the core (3, 13) over the beveled top edge (10a, 10b, 25, 26).
2. The method of claim 1 wherein said recess (15) is wedge-shaped.
3. The method of claim 1 or 2 wherein said first recess surface (15a) is arranged adjacent to and essentially parallel to said top surface layer (4).
4. The method of any one of claims 1 to 3 wherein said first and second recess surfaces (15a, 15b) are plain.
5. The method of any one of claims 1 to 4, wherein the step of closing said recess (15) includes the step of applying adhesive.
6. The method of any one of claims 1 to 5, wherein the step of closing said recess (15) includes the step of applying pressure to said ledge (16).
7. The method of any one of claims 1 to 6, wherein said ledge (16) consists essentially of said top surface layer (4).
8. The method of any one of claims 1 to 7 wherein said floor panel (2) includes a joining element (5) for connecting to a further joining element (5) of an

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adjacent floor panel (2') in a floor covering (1) formed by said floor panels (2), and the step of forming said recess (15) includes the step of simultaneously forming said joining element (5).

9. The method of any one of claims 1 to 8 wherein the step of forming said recess (15) includes the step of removing material from said side surface (13b) adjacent to said recess (15) to provide a flushing side surface after having closed said recess (15).
10. A floor panel (2) comprising a core (3, 13a) and a beveled top edge (10a, 10b, 25, 26), the panel (2) further comprising a top surface layer (4) extending continuously and in one piece from a top side (3a, 13a) of said core (3, 13) over said beveled top edge (10a, 10b, 25, 26).


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